

Date: Monday, 23/03/2009 9:53:38 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT		
Job Number	: 46641					
Estimate Number	: 11044					
P.O. Number	:			Part Number	: D28105	
This Issue	: 23/03/2009		S.O. No. :	Drawing Number	: D2810 / D2727	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	MACHINED PARTS	Drawing Revision	: C / A1
Previous Run	: 44552			Material	:	
Written By	:			Due Date	: 03/04/2009	
Checked & Approved By	: JUL 09.03.23			Qty:	10	
Comment	: Est. A 04.11.30 New issue KJ/JLM			Um:	Each	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W035	304 RD Tube .500 x .035W	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">10X</span>
		Comment: Qty.: 2.1000 f(s)/Unit Total : 21.0000 f(s) 304 RD Tube .500 x .035W Punch 304/316 SS Seamless Tubing 0.5" O.D. x 0.035" wall to length as per Dwg D2810 and spec control Dwg D2727 using Jig DT8012 Batch: M111409	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">10X</span>
2.0	BRAKE NC	NC BRAKE	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">10X</span>
		Comment: NC BRAKE 1-Length as per Dwg D2810 and spec control Dwg D2727 using Jig DT8012 2-Deburr	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">10X</span>
3.0	QC5	INSPECT WORK TO CURRENT STEP	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">10X</span>
		Comment: INSPECT WORK TO CURRENT STEP	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">10X</span>
4.0	POWDER COATING	POWDER COATING	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">10X</span>
		M105642	
		Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	
		START TIME: 1:30pm	
		OVEN TEMPERATURE: 320°f	
		FINISH TIME: 200°f	
		11 09-04-16	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">X6</span>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 9:53:38 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 46641

Part Number: D28105

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 09/04/16 (B)

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 265

9/4/16

50

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22 (P)

Job Completion



CD 09/04/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

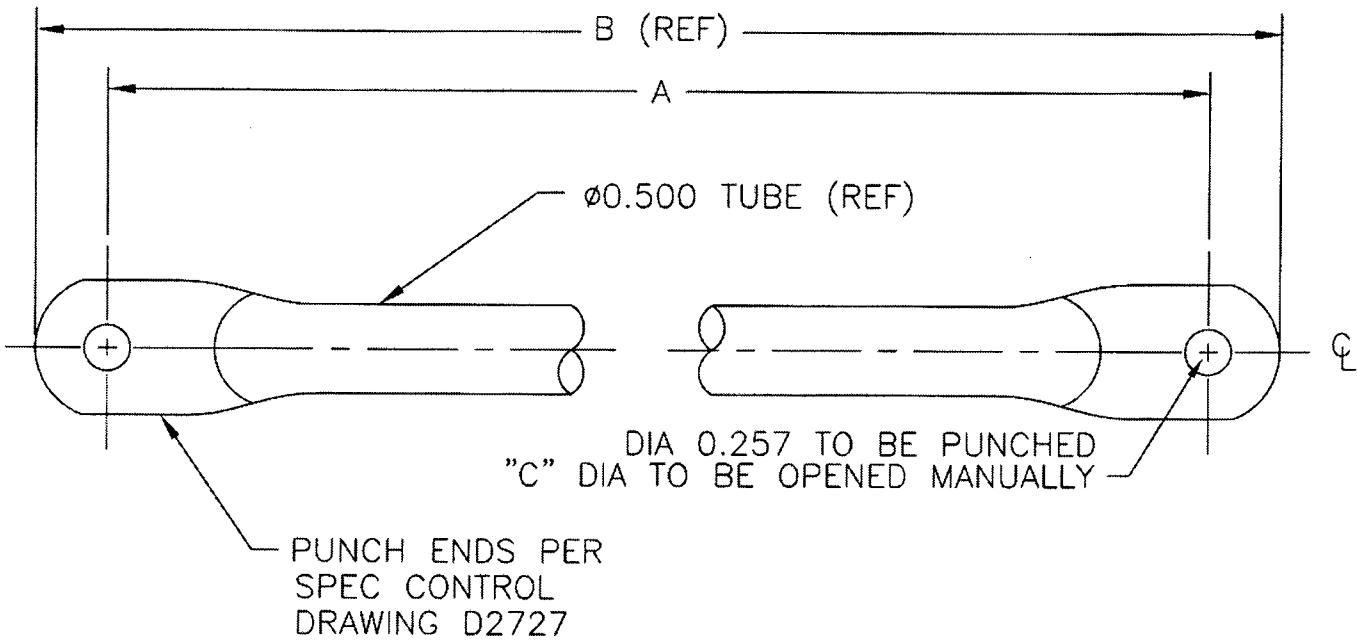
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2810	SHEET 1 OF 1
DATE		TITLE	SCALE
04.11.22		STRUT	NTS
A	00.11.08	NEW ISSUE	
B	03.09.11	ADD FINISH	
C	04.11.22	ADD -5	

RELEASED

05-13-11



PART #	A	B	C
D2810-1	25.33	26.13	N/A
D2810-3	24.60	25.40	N/A
D2810-5	23.01	23.81	0.266

D2810-1/-3/-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, Ø0.500 x 0.035 WALL (M304TR0.500W.035)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES

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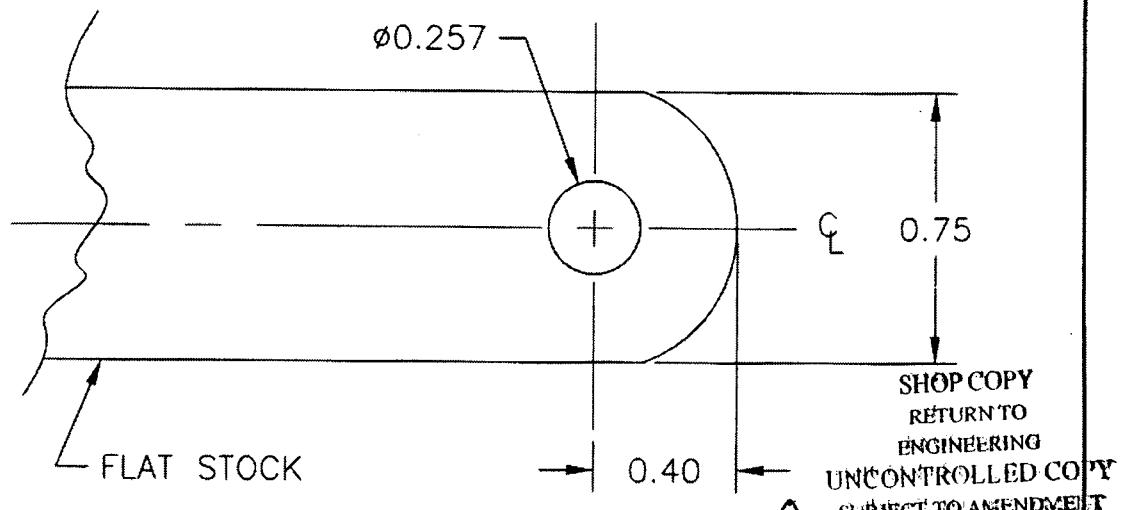
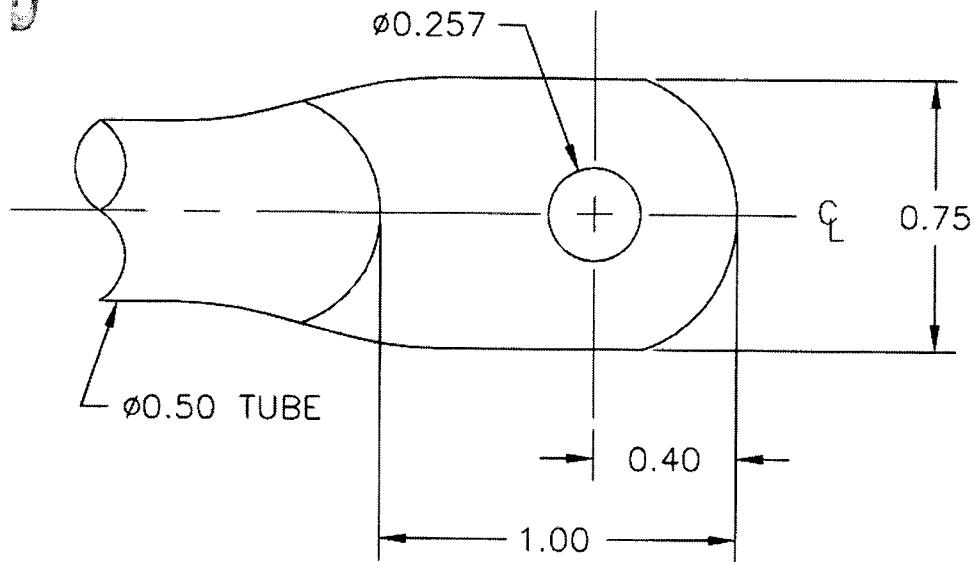
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**DART**

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CHECKED <i>DMY</i>	APPROVED <i>GA</i>	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	<i>HP</i> 01.12.20	ADD TOLERANCE NOTE	

## SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

**RELEASED**  
98/03/06 KE

NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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